

(19)



Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

**EP 0 915 401 B1**

(12)

**EUROPEAN PATENT SPECIFICATION**

(45) Date of publication and mention  
of the grant of the patent:  
**07.04.2004 Bulletin 2004/15**

(51) Int Cl.7: **G05B 19/042, G05B 19/418,  
B05B 12/00**

(21) Application number: **98121139.4**

(22) Date of filing: **10.11.1998**

**(54) Computerized virtual paint manufacturing and application system**

Virtuelles ,computergesteuertes System zur Vorbereitung und zum Auftrag von Farben

Système informatisé virtuel de préparation et d'application de peintures

(84) Designated Contracting States:  
**AT BE CH DE DK ES FR GB IE IT LI NL SE**

(30) Priority: **10.11.1997 US 966960**

(43) Date of publication of application:  
**12.05.1999 Bulletin 1999/19**

(73) Proprietor: **BASF CORPORATION**  
**Mount Olive, New Jersey 07828-1234 (US)**

(72) Inventors:  
• **Jahn, Raimar**  
**Farmington Hills, Michigan (US)**  
• **Guerrini, Edward**  
**Farmington, Michigan (US)**  
• **Lamberty, Paul**  
**Romeo, Michigan (US)**  
• **Dine, Christopher**  
**White Lake, Michigan (US)**  
• **Barach, Aimee**  
**Royal Oak, Michigan (US)**  
• **Long, Kai**  
**48165 Münster (DE)**

• **Nimphius, Dirk**  
**48151 Münster (DE)**  
• **Pitzer, Jürgen**  
**59387 Ascheberg (DE)**

(74) Representative: **Fitzner, Uwe, Dr. et al**  
**Dres. Fitzner & Münch**  
**Rechts- und Patentanwälte**  
**Lintorfer Strasse 10**  
**40878 Ratingen (DE)**

(56) References cited:  
**EP-A- 0 403 735 WO-A-93/24870**  
**WO-A-94/08544 US-A- 4 506 626**  
**US-A- 5 229 948 US-A- 5 574 656**  
**US-A- 5 631 825 US-A- 5 632 816**

• **LINNINGER A A ET AL: "Pollution prevention for  
production systems of energetic materials"**  
**WASTE MANAGEMENT, ELSEVIER, NEW YORK,**  
**NY, US, vol. 17, no. 2-3, 1997, pages 165-173,**  
**XP004108177 ISSN: 0956-053X**

Note: Within nine months from the publication of the mention of the grant of the European patent, any person may give notice to the European Patent Office of opposition to the European patent granted. Notice of opposition shall be filed in a written reasoned statement. It shall not be deemed to have been filed until the opposition fee has been paid. (Art. 99(1) European Patent Convention).

**EP 0 915 401 B1**

**BEST AVAILABLE COPY**

**Description****Background of the Invention**

[0001] The present invention relates generally to painting systems and more particularly to paint manufacturing, paint application and paint product data acquisition and processing.

[0002] Operations within automotive painting contain many devices and process controllers that chiefly work independently to achieve their individual goals. Moreover, data is individually obtained from them without a structured framework to synthesize the data so that an overall systems analysis of the painting system can be performed.

[0003] Information from automotive painting facilities is not only difficult to synthesize for an overall systems perspective, but the information leaves the "hermetic" environment of these painting facilities with great difficulty. Outside sources, such as remote customer sites, need access to this synthesized information so that they can make informed decisions about certain operational characteristics of the automotive painting factories. For instance, customers wish to know how well their experimental painting products are performing in the automotive factory environment as well as the paint manufacturers and developers. Also lacking are the tools needed by the remote sites to "fine tune" operational parameters in order to fix painting operations or chemistries that are not in tolerance with such predefined standards as MSDS standards. Accordingly, there is a need to overcome these and other disadvantages exhibited by previous approaches to operating paint-related facilities.

[0004] US 5,574,656 discloses a computer based iterative process for generating chemical entities with predefined physical, chemical and/or bioactive properties. During each iteration of the process a directed diversity chemical library is robotically generated in accordance with robotic synthesis instructions, the compounds in the directed diversity chemical library are analyzed to identify compounds with desired properties, structure-property data are used to select compounds to be synthesized in the next iteration and new robotic synthesis instructions are automatically generated to control the synthesis of the directed diversity chemical library for the next iteration, although paints are cited as one of the chemical compounds that could be generated by the process, paint related process steps comprising resin manufacturing, paint manufacturing and paint application are not explicitly mentioned.

**Summary of the Invention**

[0005] In accordance with the teachings of the present invention, a computer-implemented apparatus for coordinating paint-related process steps of at least one paint-related facility is defined by the features of the independent claim. Preferred embodiments are defined

in the dependent claims.

**Brief Description of the Drawings**

[0006] Additional advantages and features of the present invention will become apparent from the subsequent description in the appended claims, taken in conjunction with the accompanying drawings in which:

Figure 1 is a process flow diagram depicting the steps involved in the overall painting system.

Figure 2 is a network schematic diagram showing the data interconnections of the components of the preferred embodiment of the present invention;

Figure 3 is a network schematic diagram depicting the data interconnections between a painting laboratory and the virtual paint manufacturing and application system;

Figure 4 is a functional data flow diagram depicting the data flow among components of the present invention;

Figure 5a is a front view of a painting panel to be analyzed by the paint analyzer device;

Figure 5b is an exemplary contour plot output from the paint analyzer device that depicts lightness values as related to positions on the panel of Figure 5a; Figures 6a-6b are screen displays of the paint simulator computer program;

Figures 7a-7b are schematics of the memory and data structures utilized within the present invention; Figure 8 is an exemplary computer screen display for the data acquisition and interrelationship of resin manufacturing process control data;

Figure 9 is an exemplary computer screen display for the data acquisition and interrelationship of paint manufacturing process control data;

Figure 10 is an exemplary computer screen display for the data acquisition and interrelationship of vehicle assembly manufacturing process control data; Figure 11a is an exemplary computer screen display showing cross-dependencies through utilization of the links among the data structures of the present invention;

Figure 11b is an exemplary computer screen display for the level of authorization for accessing the information within the present invention;

Figure 12 is a flow chart depicting the use of the present invention to do environmental tolerance checking;

Figure 13 is a flow chart depicting the steps used in the system performing problem resolution and reporting cause and effect analysis; and

Figure 14 is a flow chart depicting the steps for utilizing the system to form a weekly cause and effect analysis report; and

Figure 15 is a computer printout depicting an exemplary weekly report as generated by the present invention.

### Description of the Preferred Embodiment

[0007] Figure 1 illustrates the overall steps in a paint manufacturing and application system. The ultimate purpose of the overall process is to apply manufactured paint onto a vehicle 50 within predefined tolerances. These tolerances include quality tolerances, and ecological tolerances.

[0008] Raw material 54 comes into the paint manufacturing and application system from an external raw material manufacturing source 62. Moreover, resin 66 comes into the paint manufacturing and application system from an internal raw material manufacturing source 70. The terms "external" and "internal" refer to the sources of the material that internal and external to the company that is responsible for the paint manufacturing and delivery of the manufactured paint to a vehicle assembly plant

[0009] Data acquisition is performed with respect to raw material 54 by raw material control process block 74. Likewise, data acquisition concerning resin 66 is performed by resin manufacturing process control block 78. The data acquired by blocks 74 and 78 is specially structured so as to provide systems-type information with respect to each process step involving raw material 54 and resin 66. Data acquisition is preferably captured through electronic sensors that sense the paint-related characteristics and electronically forward the data to the present invention for synthesis and storage. Also, the present invention supports manual entry of data as well as electronic retrieving the data needed by the present invention directly from databases. This novel data acquisition and its data structures as utilized by blocks 74 and 78 are more fully discussed below.

[0010] Formulation guidelines 82 indicate the manner by which raw material 54 and resin 66 are to be combined in the paint manufacturing process block 86 so as to produce paint material 90. These formulation guidelines 82 include such guidelines as quantity and temperature at which raw material 54 and resin 66 are to be combined. Data acquisition concerning the manufacturing of the paint is performed by the paint manufacturing process control block 88.

[0011] Paint material 90 is delivered to a vehicle assembly plant for processing within that plant as indicated by block 94. Within the vehicle assembly plant processing block 94, data acquisition is performed by assembly plant process control block 98. Block 98 acquires data related to paint material 90 and its application as the paint material 90 courses through each process step within vehicle assembly plant processing block 94. The data as acquired by paint manufacturing process control block 88 and assembly plant process control block 98 are used for such purposes as batch control 102. Batch control 102 is intended only for illustration of the use of the present invention and is not intended to limit the scope of application of the present invention. Batch control 102 includes analyzing the data acquired from

blocks 88 and 98 to determine whether paint material 90 is within predefined tolerances.

[0012] The data acquired by blocks 74, 78, 88 and 98 all reside within the computerized virtual paint manufacturing and application system 120 which structures the data so that an overall system perspective can be obtained as well as by providing an environment for entities to remotely view the data captured by the present invention.

[0013] Figure 2 shows a network schematic of the interconnections among components of the computerized virtual paint manufacturing and application system 120 and sources of data as generally depicted at 124 and recipients of the data as generally depicted at 128. Data sources 124 include data being acquired from one or more paint laboratories 132, one or more paint manufacturing factories 136, and one or more vehicle assembly plants 140.

[0014] Paint laboratories 132 provide technical data about paint material, such as mathematical models that interrelate painting factors (e.g., control settings for paint spraying equipment) with paint responses (e.g., gloss of a paint). The models are stored within the computerized virtual paint manufacturing and application system 120 in the factor-response models database 144. Moreover, paint laboratories 132 provide technical data to populate one or more of the following data structures that are contained within the computerized virtual paint manufacturing and application system 120: resin manufacturing data structure 148; paint manufacturing data structure 152; and paint application data structure 156.

[0015] The resin manufacturing data structure 148 relates to the data obtained from resin material control process block 74 and resin manufacturing process control block 78 (of Figure 1). Paint manufacturing data structure 152 corresponds to the data acquired from paint manufacturing process control block 88 (of Figure 1). Also, paint application data structure 156 corresponds to the data acquired from the assembly plant process control block 98 (of Figure 1).

[0016] Data structures 148, 152 and 156 are located on one or more computers as generally depicted at 160. The data structures 148, 152, and 156 provide a novel structure for assisting in data acquisition from the data sources 124 and in the presentation and analysis of the data by data recipients 128.

[0017] Computers 160 are preferably located within the physical location of the source of the data. For example, the data that is acquired from paint manufacturing factory 136 is preferably placed into a computer that is located at the paint manufacturing factory 136. Likewise, a computer containing the paint application data structure 156 is located at a vehicle assembly plant 140. Data structures 148, 152 and 156 and computers 160 are collectively termed the process control coordinator 162. Computers 160 have the capability to input and to view data that is stored in databases located on net-

works 169 subject to computerized security authorization.

[0018] The information as structured by data structures 148, 152, and 156 are able to be retrieved and analyzed by the data recipients 128, such as at a paint manufacturer remote sites 164 and at customer remote sites 168. To allow the data recipients 128 to analyze the painting system from an overall systems perspective, a technical database 172 provides additional paint-related data, such as, but not limited to, ecological and internal company quality standards.

[0019] Networks 169 connect the various components of the system so that data communication can occur. The preferred embodiment for networks 169 utilizes an Intranet network 173 to perform data communication between components within the computerized virtual paint manufacturing and application system 120 and within the data sources 124. Moreover, paint manufacturer's remote sites are connected to Intranet 173. The customer remote sites 168 are connected to an Extranet network 175 to better ensure proper security exists in accessing the data from the computerized virtual paint manufacturing and application system 120. Security data is located preferably in technical database 172 for ensuring that only authorized users (whoever and wherever they may be) can view the portions of the information contained within the computerized virtual paint manufacturing and application system 120 that they are authorized to view.

[0020] Figure 3 depicts the preferred embodiment for the data interconnection between one of the paint laboratories 132 and the computerized virtual paint manufacturing and application system 120. Within paint laboratory 132, painting equipment 242 is controlled by control settings 244 in order to spray paint upon vehicles. The sprayed paint is analyzed by a paint analyzer device 246. The paint analyzer device 246 examines the physical characteristics of the sprayed paint so that subsequent analysis can reveal how the paint responds under various conditions and under various formulations. The paint analyzer device 246 examines such physical characteristics as, for example, color (e.g., L, a, b values at different angles), leveling (in the form of wave scanned values), gloss, haze, and film thickness. In the preferred embodiment, paint analyzer device 246 is a device known as "PROSIM" which is obtainable from BASF.

[0021] Paint analyzer device 246 is preferably in data communication with a paint simulation computer program 248. Paint simulation computer program 248 models the interrelationship between automotive painting equipment and the sprayed paint so that desired painting characteristics can be achieved. A factor-response models database 144 is used for storing mathematical models which interrelate painting factors with painting responses. Painting factors relate to the control settings 244 of the painting equipment 242. Painting responses relate to such painting characteristics as those that may

be obtained from the paint analyzer device 246.

[0022] Paint simulation computer program 248 employs design of experiment techniques, as well as optimization techniques in order to determine the values for the painting responses based upon desired painting tolerances to be achieved. For a more complete understanding of the paint simulation computer program 248, please refer to U.S. Serial No. 08/822,669 (entitled "Paint Equipment Set-up Method and Apparatus"), filed March 24, 1997.

[0023] Paint simulation computer program 248 has as one of its purposes the capability of identifying regions within the mathematical models that need to be better defined. For example, a range of painting factor values that result in relatively low R-squared values for the paint responses indicate regions within the mathematical models that need refinement. These regions within the mathematical models are specifically tested through a design of experiments technique by the paint laboratory, and data points are collected by the paint analyzer device 246. The design of experiments factor-response models are refined to incorporate this additional detail.

[0024] Computer 160 utilizes paint manufacturing data structure 152 to acquire data from paint analyzer device 246 and paint simulation computer program 248. This acquired data is used for several purposes including performing batch control (i.e., to ensure compliance with quality standards as contained in the technical database). Such paint characteristic data as the paint film thickness data from the paint analyzer device 246 is interrelated with the type of paint material within the paint manufacturing data structure 152.

[0025] Another example is the following. The paint simulation computer program 248 performs design of experiments calculations based upon the data from the paint analyzer device 246 in order to identify which parameters and variables are key in the paint manufacturing and vehicle assembly factory. These identified key parameters are inserted into the process control data structures (such as the paint manufacturing data structure and the vehicle assembly data structure).

[0026] Figure 4 shows the detailed informational flow among the aforementioned components of the present invention. In the preferred embodiment, the PROSIM device 246 provides paint characteristic data to the paint simulation computer program 248 so that factor/control settings can be determined to produce certain paint appearance and application responses of the sprayed paint.

[0027] The data from the PROSIM device 246 is used by the process control coordinator 162 in order to perform batch control. Within that capacity, the PROSIM device 246 allows paint material from a paint manufacturing plant to be analyzed to ensure compliance with predefined quality standards. The batch control data from the PROSIM device 246 is used to populate the paint manufacturing data structure 152 (especially with respect to the quality forward portion of the data struc-

ture).

[0028] As described above, paint simulation computer program 248 uses factor-response models database 144 in order to perform its design of experiments calculations. Also, paint simulation computer program 248 updates factor-response models database 144 based upon actual paint spraying system performance data as provided by PROSIM device 246. Paint simulation computer program 248 along with the factor-response models database 144 provides the ability to monitor and control variable parameters via technical database 172. Technical database 172, in its preferred embodiment, contains such information as paint product portfolio information 270, ecology information 272, communication information 274, and quality information 276 (such as first run capability). Technical database 172 also contains concern and analysis request forms 280 so that issues and concerns and their subsequent analysis and resolution can be captured. Security data 277 about how an entity that is external to the computerized virtual paint manufacturing and application system 120 may access the information is also contained in the technical database 172.

[0029] Process control coordinator 162 synthesizes and packages the data from the data sources so that remote systems can efficiently and effectively analyze the historical, current and potential operational characteristics of the entire painting system (i.e., life history analysis). Process control coordinator 162 synthesizes and packages the data into the resin manufacturing data structure 148, paint manufacturing data structure 152, and the paint application data structure 156 based upon the type of data provided and which particular data source provided the data.

[0030] Additionally, process control coordinator 162 provides problem resolution and reporting information to the data destinations based upon the information captured by the computerized concern and analysis request forms 280. The problem resolution reporting module 282 allows the data destination remote sites to use previous solutions to similar problems in order to solve existing problems. Moreover, a weekly report module 284 of the process control coordinator 162 provides for an automated capability to send the information from the various components of the present invention to the data destination remote sites.

[0031] Process control coordinator 246 provides a time stamp for each datum received from the data sources. Not only does this create a historical baseline snapshot 285, but it also allows the amount of change at different times in the entire paint manufacturing system to be analyzed.

[0032] Figure 5a shows how the PROSIM device captures paint characteristic data from panel 290. The regions as exemplarily identified by reference numeral 291 illustrate where the PROSIM device performs its measurements. For this example, a varying amount of basecoat 292 was applied to panel 290. The panel's top

290a contained a thin coating of basecoat whereas the panel's bottom 290b contained a greater amount of basecoat. For this example, a consistent amount of clearcoat 294 was applied to panel 290. The varying amount of clearcoat with respect to basecoat 292 is possible with the PROSIM device since the PROSIM device captures paint characteristic data across the entire panel.

[0033] To illustrate the entire panel analysis approach of the PROSIM device, figure 5b shows a sample contour plot 300 output from the PROSIM device that interrelates lightness value of the paint with the position of the paint on the panel of Figure 5a. The abscissa axis 302 shows the vertical position values of the panel while the ordinate axis 304 shows the horizontal position values of the panel. Regions within contour plot 300 reveal how the lightness values vary over panel position. For example, region 306 depicts an area on the panel that has a lightness value as provided on reference bar 308.

[0034] Figure 6a is an exemplary screen display from the paint simulation computer program wherein factor/control settings of the paint spraying equipment is generally shown at 330. The factor settings are interrelated through mathematical models with certain responses of the sprayed paint as generally shown at 334 and 338. The mathematical models were generated through design of experiments techniques. In this example, the bell speed, shaping, and bell fluids factor/control settings 330 produce via the mathematical models the paint appearance and application air response as shown at reference numerals 334 and 338.

[0035] With reference to Figure 6b, an optimizer 342 is utilized to maintain one or more of the factor/control settings and/or response values at a certain level or range while allowing other settings and/or responses to vary within a predefined range. In this example, the shaping air and bell fluids factor/control settings were respectively fixed at 36 pounds per square inch and 295 cubic centimeters/minute. Moreover, in this example the average film build response was fixed by the optimizer 342 to be within the range 0.90 to 1.0 mils. optimizer 342 preferably employs a simplex algorithm such as the one provided by the Microsoft Excel<sup>TM</sup> software product.

[0036] Figure 7a depicts the process control data structure template 353 as contained in the computer memory 360 of computer 160. These components are part of the process control coordinator 162.

[0037] Process control data structure template 353 interrelates paint-related data with one or more relevant process steps of the paint spraying system. The process steps 364 include the steps used within the process of a paint laboratory, or a resin manufacturing factory, or a paint manufacturing factory, or a vehicle assembly plant. For example, a process step within a vehicle assembly plant may include the process step of when the paint is in storage or when the paint is in the mixing room, or the particular sprayed paint coating that has been applied to a vehicle.

**[0038]** Painting equipment data structure 368 interrelates with relevant process steps 364 such painting equipment related data as equipment type, accessories, and equipment configuration.

**[0039]** Process data structure 370 interrelates with relevant process steps 364 such process-related data as environmental parameters, constant parameters, and variable parameters. Environmental parameters include such items as line speed, booth temperature, and humidity. Constant parameters include, but are not limited to, application parameters that are substantially constant for each paint (e.g., oven temperature/profile, target distance). Variable parameters include, but are not limited to, application parameters that are different for each paint (e.g., fluid rate, bell speed).

**[0040]** Materials data structure 372 captures and stores such material related data as material parameters, additions to the material mixture, and consumption data. Specifically, consumption data refers to usage information, such as for example, consumption of resources or materials for a particular time period (e.g., on a daily basis) or consumption of resources or materials for a vehicle. Materials data structure 372 is preferably not interrelated with the process steps since typically materials-related data is not acquired until the end of an entire process (such as, at the end of the resin manufacturing process).

**[0041]** Quality forward data structure 373 captures and stores such quality forward-related data as testing data and evaluation data. The term "quality forward" refers to quality checking for such items as defects in the material before the material is produced by a painting facility. Quality forward typically uses laboratory testing to formulate predictions about how a material should perform in production. The paint laboratory configuration of Figure 3 is preferably used to formulate such predictions for the quality forward data structure 373. Quality forward data structure 373 is preferably not interrelated with the process steps since typically the quality forward-related data is acquired before a process for a product begins (such as, at the beginning of the paint manufacturing process).

**[0042]** With reference to Figure 7b, quality backward data structure 374 captures and stores such quality backward related data as first category quality backward data, second category quality backward data, and third category quality backward data. Quality backward data structure 374 interrelates with relevant process steps 364 such quality backward-related data as typically three categories of quality backward data. The first category addresses in-process batch control. The second category addresses defect-kind/type, quantification, and evaluation. The third category addresses: problem description, interim containment actions, potential causes(s) identification, root cause identification, verification of corrective actions, permanent corrective actions, and preventative actions. It should be noted that the present invention is not limited to three categories, but may in-

clude only one or two categories depending on the specification application. For example, the paint application data structure preferably contains only categories two and three for the quality backward related data since typically in-process batch control is not performed within the paint application process.

**[0043]** The term "quality backward" refers to adjusting the process based upon quality predictions, issues and resolutions identified in the "quality forward" data structure. In this capacity, "quality backward" operates as a feedback loop to fine tune the process.

**[0044]** People-related data structure 375 interrelates with relevant process steps 364 such people-related data as standard training program, job title, and job descriptions.

**[0045]** Painting economic data structure 376 interrelates with relevant process steps 364 such painting economic data as the money amount per kilogram per gallon of a particular paint type, the amount of money to spray a predefined automotive vehicle, and quality cost that is internal as well as external.

**[0046]** Lastly, an agreement data structure 384 is provided so as to interrelate contractual data, such as contract identification number and parties and obligations relevant to an agreement with relevant process steps 364.

**[0047]** Process control coordinator 162 creates and maintains the process control data structure template 353 during the data acquisition steps from each data source.

**[0048]** Figure 8 depicts the preferred embodiment of the process control data structure template for the resin manufacturing data structure 148. The process steps which are to be interrelated with the equipment, process, quality backward, people, economy, and agreement modules of the resin manufacturing data structure 148 are the following: material receipt, material storage, reactor/vessel preparation, intermediate processing, reactor/vessel charging, process, batch adjustment, material transfer, filtration, filling, equipment cleaning, product storage, and product delivery. It should be understood that the present invention is not limited to these process steps. The above list serves only for sake of example, and can be expanded or reduced based upon the specific application at hand.

**[0049]** The primary input materials described by the resin manufacturing data structure 148 is the chemicals that are used to produce the resins. The chemicals and their properties are described within the raw materials module of the resin manufacturing data structure 148. The primary output product described by the resin manufacturing data structure 148 are the resins that are produced from the chemicals.

**[0050]** Figure 9 depicts the preferred embodiment of the process control data structure template for the paint manufacturing data structure 152. The process steps which are to be interrelated with the equipment, process, quality backward, people, economy, and agree-

ment modules of the paint manufacturing data structure 152 are the following: material receipt, material storage, staging of materials, equipment preparation, raw material transfer, intermediate processing, batch blending, batch adjustment, filling process, equipment cleaning process, product storage, and product delivery to the vehicle assembly plant. It should be understood that the present invention is not limited to these process steps. The above list serves only for sake of example, and can be expanded or reduced based upon the specific application at hand.

[0051] The primary input materials described by the paint manufacturing data structure 152 are the resins that are the products of the resin manufacturing data structure 148 and external raw materials (such as, for example, pigments; the external raw materials are shown by reference numeral 62 on Figure 1). The resins, the external raw materials, and the properties associated with them are described within the raw materials module of the paint manufacturing data structure 152. The primary output product described by the paint manufacturing data structure 152 are the manufactured paint materials that are produced from the resins and the external raw materials.

[0052] Figure 10 depicts the preferred embodiment of the process control data structure template for the paint application data structure 156. The process steps which are to be interrelated with the equipment, process, quality backward, people, economy, and agreement modules of the paint application data structure 156 are the following: storage-customer, storage-customer mixroom, mixroom, pre-cleaning, phosphate, electrocoat, cleaning-manual, cleaning-automation, manual application, robots-interior/exterior, rotational atomizers-bells, air atomizers-reciprocator, flash-off, blow-off, infrared, ovens, miscellaneous automated applications, manual auxiliary operations, automatic auxiliary operations, zone without application operation, sealant, underbody prime, wax, window glazing, transportation concerns, and coagulation. It should be understood that the present invention is not limited to these process steps. The above list serves only for sake of example, and can be expanded or reduced based upon the specific application at hand.

[0053] The primary input materials described by the paint application data structure 156 are the paint materials that are the products of the paint manufacturing data structure 152. The paint materials and their properties are described within the materials module of the paint application data structure 156. The primary output product described by the paint application data structure 156 are the paint coatings upon vehicles.

[0054] Since variation exists within each painting process (i.e., resin manufacturing, paint manufacturing and paint application process), data structures 148, 152, and 156 are structured so that variations and cross-dependencies between materials and process steps can be analyzed within each painting process. Moreover, at

least one common denominator/link exists among the data structures 148, 152, and 156 so that variations and cross-dependencies between materials and process steps can be analyzed across the entire painting process. Preferably, the link among the data structures 148, 152, and 156 are the output materials from one data structure that corresponds to the input material to another data structure. For example, the resin material from the resin manufacturing data structure 148 is used to link with information contained in the paint manufacturing data structure 152 since the output of the resin manufacturing data structure 148 corresponds to the input of the paint manufacturing data structure 152. Numeric identifiers are preferably used to uniquely identify the materials that link the data structures. Figure 11 a is a computer screen display that provides an example of using the links between the data structures to examine cross-dependencies from one paint process to another. In this non-limiting example, the problem as identified in the quality backward data structure is traced back across materials and processes to the possible root cause of a wrong quality assurance test being used to certify that Resin #419 is acceptable for use in production. Moreover, it should be understood that the present invention is not limited to only linking two data structures but includes linking all three data structures to form a complete life history view of the entire system, for example, by providing a life history view from the paint application data structure 156 through the paint manufacturing data structure 152 to the resin manufacturing data structure 148.

[0055] Figure 11b depicts the preferred embodiment to ensure that the data is viewed by data destination remote sites in a secured manner. For example, the paint plant area managers which would be identified by a computer system identifier would only be able to view data within the present invention that relates to its own plant.

[0056] Figure 12 depicts the steps wherein the data destination remote sites uses the information from the various components of the present invention in order to control the paint spraying system. At process block 400, a user, such as a customer, from a remote site obtains certain technical information regarding the paint spraying system. In order to obtain product data sheets, a customer invokes process block 404 by preferably clicking on an icon on the screen of the data destination remote site for a specific paint-related product. The requested product data sheet is retrieved from the technical data base and is sent to the customer at process block 408. At process block 412, a customer industrial hygiene group reviews the product data sheet information and performs at process block 416 all relevant emissions data. Preferably, the data destination remote site automatically calculates for the group the emissions data and produces a report that determines whether the volatile organic compounds (VOCs) and emissions data are in the specified range as determined by the ecological

threshold values contained within the technical database. This determination is performed by decision block 420.

[0057] If decision block 420 determines that all VOCs and emissions data are in the specified range, then the product is determined to be "useful" at process block 424. However, if decision block 420 determines that the specified ranges have been violated, then the data destination remote site utilizes the paint simulation computer program and the data in the technical database in order to return the paint formulation back within the specified range. This processing is performed by process block 428.

[0058] Figure 13 depicts the steps for using the present invention in performing a problem resolution and reporting cause and effect analysis. The term "VIS" refers to the information presentation portions of the present invention to the data recipients.

[0059] At process block 440, a customer detects a problem occurring in a customer assembly plant. The customer accesses the process control coordinator data in order to determine at decision block 448 whether a similar problem has occurred in the past. If the problem has not occurred in the past, then the customer initiates at process block 452 the concern analysis form that is contained within the technical database of the present invention. Subsequently, process block 456 initiates a resolution procedure and updates the technical database with the manner in which the concern was addressed and solved. At process block 460, the customer is able to access the technical database in order to check on the status of any open PR&Rs (i.e. Problem Resolution and Reporting).

[0060] If decision block 448 has determined that the problem has previously occurred, then the customer at process block 464 identifies the stored corrective actions taken with respect to that similar problem. If corrective actions are still in place and still being used within the factory environment as determined by decision block 468, then process block 452 is executed.

[0061] However, if past corrective actions are not in place and not being used, then decision block 472 of the data destination remote site determines who has responsibility for the corrective action implementation. Decision block 472 bases this information chiefly upon the agreement data structure of the process control coordinator. If the customer has the responsibility, then at process block 476 the customer investigates the failure and reimplements or changes the corrective action plan. The customer at process block 476 uses the information contained within the technical database, as well as the information from the paint simulation computer program and the process control coordinator in order to investigate and correct the failure. If the factory has the responsibility for the corrective action as determined by the agreement data structure, then the data destination remote site notifies factory personnel at process block 480 so that the factory personnel can investigate the failure

and report resolution to the customer at process block 484.

[0062] Figure 14 shows the steps involved in generating and utilizing automated weekly reports from the process control coordinator in order to analyze and control the operational parameters of the paint spraying system. At process block 500, factory technical service representatives input batch specific data into the process control coordinator data structures in real time. The batch specific data includes product data, plant data, batch performance data, and defect occurrence and type of defect. The process control coordinator generates a product-specific report that details the activities in the factory using information provided by the technical databases and the process control coordinator data structures.

[0063] At process block 504, plant personnel access the weekly report from the process control coordinator so that at process block 508 the plant personnel can use the information to track performance and consistency. This information is used for problem solving and to track defect occurrence by product. Moreover, the weekly report is automatically produced for customers at process block 512. The customer uses the automatic weekly report for such operational analyses as: tracking batches in specific time frames for warranty claims investigation; staying current with plant product and process changes; accessing information on trial and experimental products; accessing assembly plant product information; tracking factory performance in assembly plant; and viewing assembly plant first run capability weekly by product.

[0064] Figure 15 illustrates a sample weekly report as provided by the present invention. Within the weekly report is shown what specifically occurred during what time frame for a specific paint. Such information can be used to detect problems with respect to a batch for a particular week or over several weeks.

## Claims

1. A computer-implemented apparatus for coordinating paint-related process steps of at least one paint-related facility (132,136,140,164,168), said paint-related process steps exhibiting paint-related characteristics, the apparatus comprising:

- a data acquisition module (78,88,98) for acquiring paint characteristic data indicative of the paint-related characteristics;
- a paint process control data structure (353) for interrelating said acquired paint characteristic data with at least two of the paint-related process steps to produce interrelated paint process control data;
- a paint process control coordinator (162) connected to said data acquisition module for stor-

ing said acquired paint characteristic data in said paint process control data structure; a data display connected to said paint process control data structure for remotely receiving and viewing said interrelated paint process control data,

characterized in that it further comprises:

a paint analyzer device (248) for generating sprayed paint characteristic data based upon analyzing paint sprayed by paint spraying equipment, said sprayed paint exhibiting sprayed paint characteristics, said paint process control data structure storing said sprayed paint characteristic data; and a paint simulator (248) for determining operational parameters for operating said paint spraying equipment.

2. The apparatus of Claim 1 wherein said process control data comprises a resin manufacturing data structure (148), a paint manufacturing data structure (152) or a paint application data structure (156) or combinations thereof.

3. The apparatus of Claim 1 or 2 wherein said process control data structure includes at least one, preferably two data structures being selected from the group consisting of an equipment module data structure (368), a process module data structure (370), a material data structure (372), a quality forward data structure (373), a quality backward data structure (374), a people data structure (375), an economy data structure (376), an agreement data structure (384), and combinations thereof.

4. The apparatus according to one of the claims 1 to 3 which coordinates paint-related process steps at a plurality of paint-related facilities.

5. The apparatus according to one of the claims 1 to 4 wherein said paint characteristic data includes economic data related to the paint-related process steps.

6. The apparatus of Claim 1 wherein said paint simulator is configured to determine said operational parameters based upon a design of experiments model involving at least one of the sprayed paint characteristics.

7. The apparatus according to one of the claims 1 to 6 further comprising:

an optimizer (342) connected to said paint simulator for constraining the permissible range of said operational parameters of said paint

spraying equipment.

8. The apparatus of Claim 7 further comprising:

a simplex calculator connected to said optimizer for constraining said permissible range of operational parameters.

9. The apparatus according to one of the claims 1 to 8 further comprising:

second or more data displays connected to said paint process control data structure for remotely receiving and viewing said interrelated paint process control data.

10. The apparatus of Claim 9 further comprising:

a security database (277) for providing security authorizations with respect to said plurality of data displays for remotely receiving and viewing said interrelated paint process control data.

## 25 Patentansprüche

1. Computerimplementierte Vorrichtung zum Koordinieren von farbbezogenen Prozessschritten mindestens einer farbbezogenen Anlage (132, 136, 140, 164, 168), wobei die farbbezogenen Prozessschritte farbbezogene Charakteristiken aufweisen, wobei die Vorrichtung folgendes umfaßt:

ein Datenerfassungsmodul (78, 88, 98) zum Erfassen von Farbcharakteristikdaten, die die farbbezogenen Charakteristiken anzeigen;

eine Farbprozeßsteuerdatenstruktur (353) zum Interrelieren der erfaßten Farbcharakteristikdaten mit mindestens zwei der farbbezogenen Prozessschritte zum Erzeugen interrelierter Farbprozeßsteuerdaten;

einen Farbprozeßsteuerkoordinator (162), der mit dem Datenerfassungsmodul verbunden ist, um die erfaßten Farbcharakteristikdaten in der Farbprozeßsteuerdatenstruktur zu speichern;

ein mit der Farbprozeßsteuerdatenstruktur verbundenes Datendisplay zum abgesetzten Empfangen und Betrachten der interrelierten Farbprozeßsteuerdaten und

eine Farbanalysatoreinrichtung (246),

**dadurch gekennzeichnet, daß**  
die Farbanalysatoreinrichtung (246) Sprühfarbcharakteristikdaten auf der Basis der Analyse von von

- einem Farbsprühergerät gesprühter Farbe erzeugt, wobei die gesprühte Farbe Sprühfarbcharakteristiken aufweist, wobei die Farbprozeßsteuerdatenstruktur die Sprühfarbcharakteristikdaten speichert; und  
 5 sie weiterhin einen Farbsimulator (248) zum Bestimmen von Betriebsparametern für das Betreiben des Farbsprühergeräts umfaßt.
2. Vorrichtung nach Anspruch 1, wobei die 10 Prozeßsteuerdaten eine Harzherstellungsdatenstruktur (148), eine Farbherstellungsdatenstruktur (152) oder eine Farbauftragsdatenstruktur (156) oder Kombinationen davon umfassen.
3. Vorrichtung nach Anspruch 1 oder 2, wobei die Prozeßsteuerdatenstruktur mindestens eine, bevorzugt zwei Datenstrukturen enthält, die ausgewählt sind aus der Gruppe bestehend aus einer Geräte- 15 moduldatenstruktur (368), einer Prozeßmoduldatenstruktur (370), einer Materialdatenstruktur (372), einer Qualitätsvorwärtsdatenstruktur (373), einer Qualitätsrückwärtsdatenstruktur (374), einer Personendatenstruktur (375), einer Wirtschaftsdatenstruktur (376), einer Vereinbarungsdatenstruktur (384) und Kombinationen daraus.
4. Vorrichtung nach einem der Ansprüche 1 bis 3, die farbbezogene Prozeßschritte bei mehreren farbbezogenen Anlagen koordiniert. 30
5. Vorrichtung nach einem der Ansprüche 1 bis 4, wobei die Farbcharakteristikdaten die die farbbezogenen Prozeßschritte betreffenden Wirtschaftsdaten enthalten. 35
6. Vorrichtung nach Anspruch 1, wobei der Farbsimulator so konfiguriert ist, daß er die Betriebsparameter auf der Basis eines Designs von Versuchsmo- 40 delln mit mindestens einem der Sprühfarbcharakteristiken bestimmt.
7. Vorrichtung nach einem der Ansprüche 1 bis 6, die weiterhin folgendes umfaßt: 45
- einen an den Farbsimulator angeschlossenen Optimierer (342) zum Einschränken des zulässigen Bereichs der Betriebsparameter des Farbsprühergeräts.
8. Vorrichtung nach Anspruch 7, die weiterhin folgendes umfaßt: 50
- einen mit dem Optimierer verbundenen Simplexrechner zum Einschränken des zulässigen Bereichs von Betriebsparametern. 55
9. Vorrichtung nach einem der Ansprüche 1 bis 8, die

weiterhin folgendes umfaßt:

ein mit der Farbprozeßsteuerdatenstruktur verbundenen zweites oder weitere Datendisplays zum abgesetzten Empfangen und Betrachten der interrelierten Farbprozeßsteuerdaten.

10. Vorrichtung nach Anspruch 9, die weiterhin folgendes umfaßt:

eine Sicherheitsdatenbank (277) zum Bereitstellen von Sicherheitsauthorisierungen bezüglich der mehreren Datendisplays zum abgesetzten Empfangen und Betrachten der interrelierten Farbprozeßsteuerdaten.

## Revendications

1. Appareil à mise en oeuvre informatique permettant de coordonner des étapes de processus liées à la peinture d'au moins une installation liée à la peinture (132, 136, 140, 164, 168), lesdites étapes de processus liées à la peinture présentant des caractéristiques liées à la peinture, l'appareil comprenant :

un module d'acquisition de données (78, 88, 98) permettant d'acquérir des données de caractéristiques de peinture indiquant les caractéristiques liées à la peinture ;

une structure de données de commande de processus de peinture (353) permettant de mettre en corrélation lesdites données de caractéristiques de peinture acquises avec au moins deux desdites étapes de processus liées à la peinture en vue de produire des données de commande de processus de peinture corrélées ;

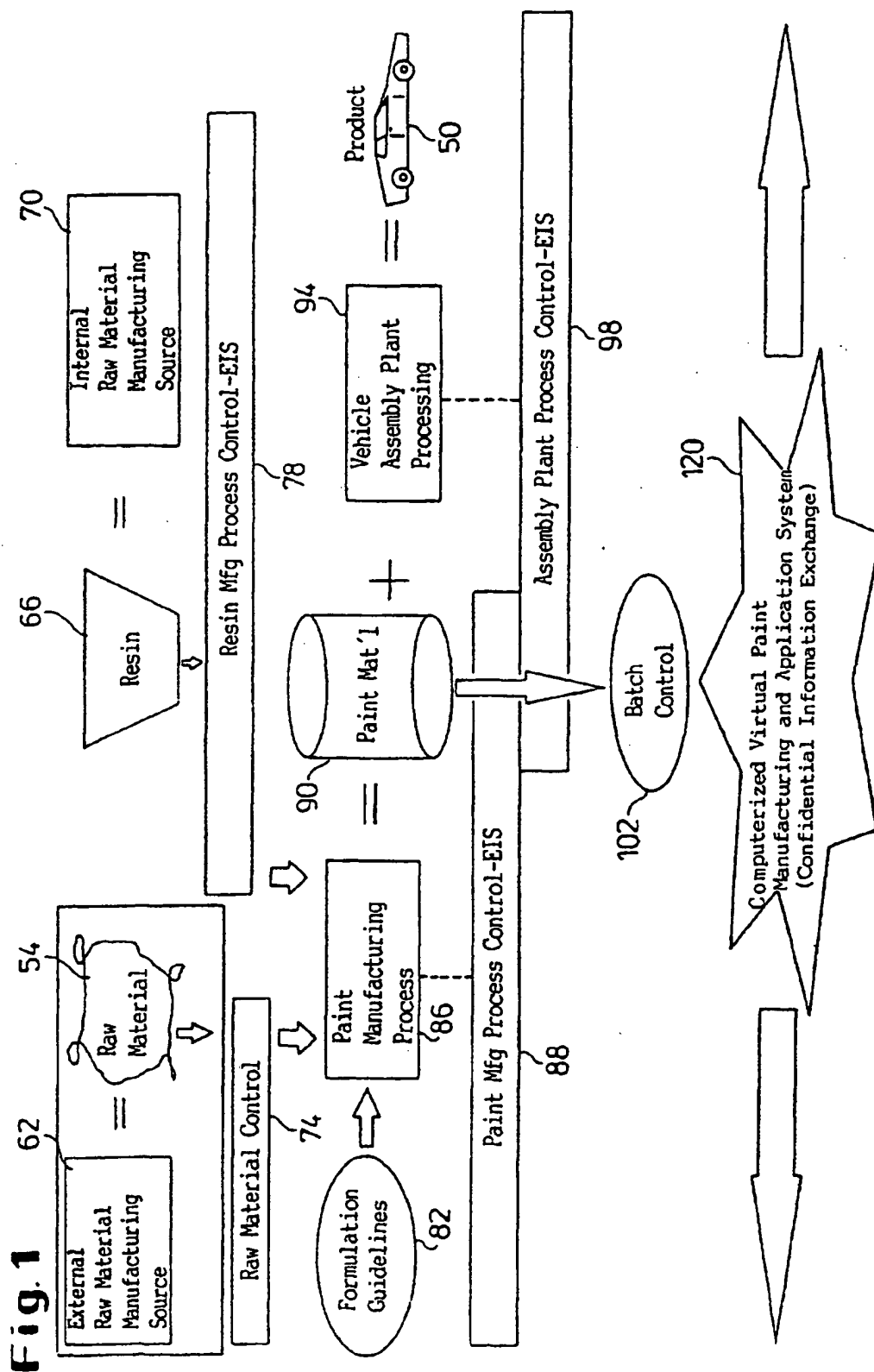
un coordinateur de commande de processus de peinture (162), raccordé audit module d'acquisition de données, destiné à stocker lesdites données de caractéristiques de peinture acquises dans ladite structure de données de commande de processus de peinture ;

un affichage de données, raccordé à ladite structure de données de commande de processus de peinture, permettant de recevoir et de visualiser à distance lesdites données de commande de processus de peinture corrélées, et un dispositif analyseur de peinture (246),

caractérisé en ce que :

le dispositif analyseur de peinture (246) génère des données de caractéristiques de peinture pulvérisée en fonction de l'analyse d'une peinture pulvérisée par un équipement pulvérisa-

- teur de peinture, ladite peinture pulvérisée présentant des caractéristiques de peinture pulvérisée, ladite structure de données de commande de processus de peinture stockant lesdites données de caractéristiques de peinture pulvérisée ; et  
il comprend en outre un simulateur de peinture (248) permettant de déterminer des paramètres de fonctionnement pour faire fonctionner ledit équipement pulvérisateur de peinture. 5
2. Appareil selon la revendication 1, dans lequel lesdites données de commande de processus comprennent une structure de données de fabrication de résine (148), une structure de données de fabrication de peinture (152) ou une structure de données d'application de peinture (156), ou des combinaisons de celles-ci. 15
3. Appareil selon la revendication 1 ou 2, dans lequel ladite structure de données de commande de processus comporte au moins une structure de données, de préférence deux, choisie dans le groupe constitué d'une structure de données de module d'équipement (368), une structure de données de module de processus (370), une structure de données de matière (372), une structure de données de qualité amont (373), une structure de données de qualité aval (374), une structure de données de personnes (375), une structure de données d'économie (376), une structure de données d'accord (384), et des combinaisons de celles-ci. 20 25 30
4. Appareil selon l'une quelconque des revendications 1 à 3, lequel coordonne des étapes de processus liées à la peinture au niveau d'une pluralité d'installations liées à la peinture. 35
5. Appareil selon l'une des revendications 1 à 4, dans lequel lesdites données de caractéristiques de peinture comportent des données économiques liées aux étapes de processus liées à la peinture. 40
6. Appareil selon la revendication 1, dans lequel ledit simulateur de peinture est configuré pour déterminer lesdits paramètres de fonctionnement en fonction d'un plan d'un modèle expérimental mettant en jeu au moins une des caractéristiques de peinture pulvérisée. 45 50
7. Appareil selon l'une des revendications 1 à 6, comprenant en outre :  
un optimiseur (342), raccordé audit simulateur de peinture, permettant de limiter la plage admissible desdits paramètres de fonctionnement dudit équipement pulvérisateur de peinture. 55
8. Appareil selon la revendication 7, comprenant en outre :  
un calculateur simplex, raccordé audit optimiseur, permettant de limiter ladite plage admissible de paramètres de fonctionnement.
9. Appareil selon l'une des revendications 1 à 8, comprenant en outre :  
un deuxième affichage de données, voire davantage, raccordé à ladite structure de données de commande de processus de peinture, permettant de recevoir et de visualiser à distance lesdites données de commande de processus de peinture corrélées.
10. Appareil selon la revendication 9, comprenant en outre :  
une base de données de sécurité (277) permettant de fournir des autorisations de sécurité en relation avec ladite pluralité d'affichages de données permettant de recevoir et de visualiser à distance lesdites données de commande de processus de peinture corrélées.



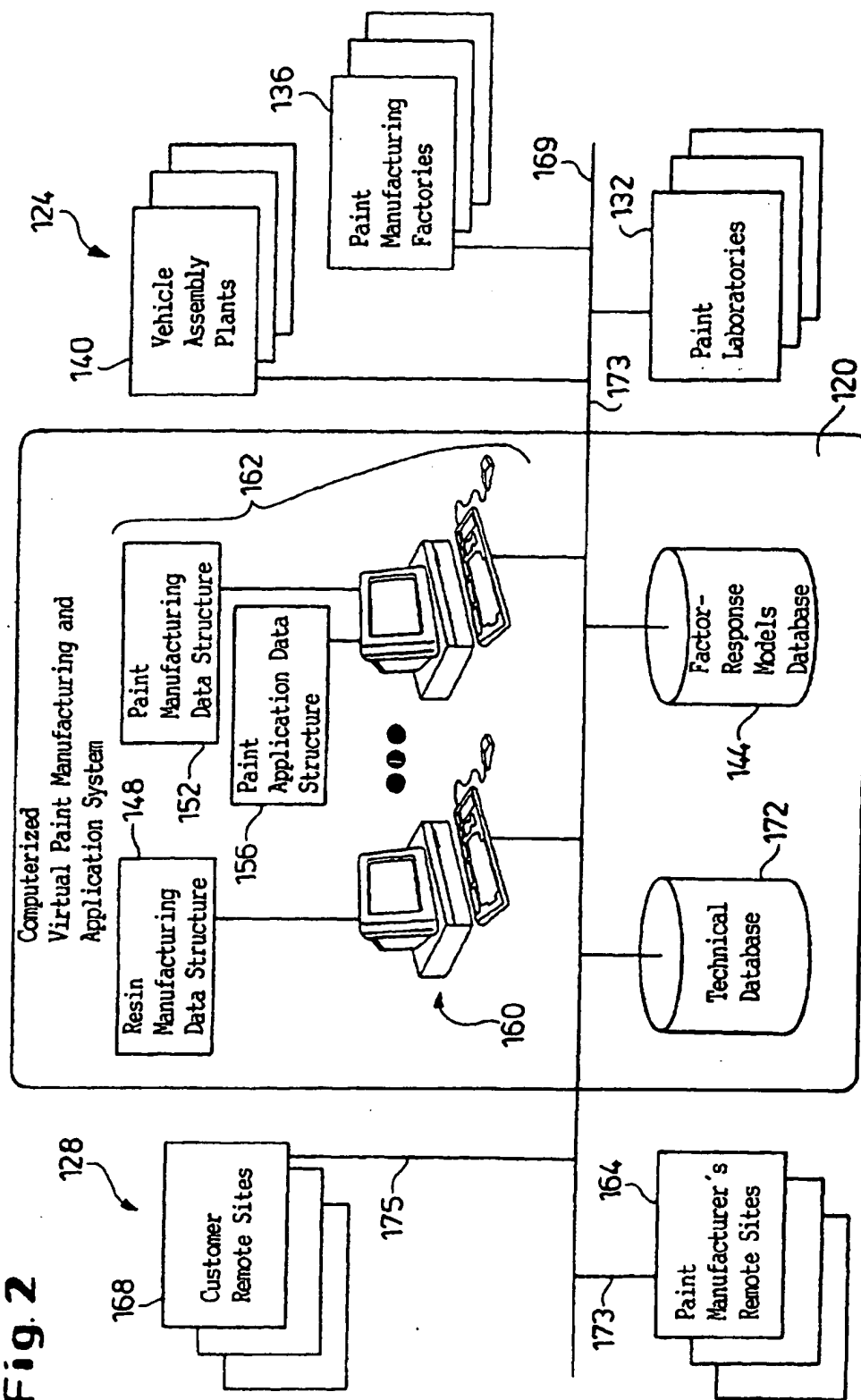
**Fig. 2**

Fig. 3

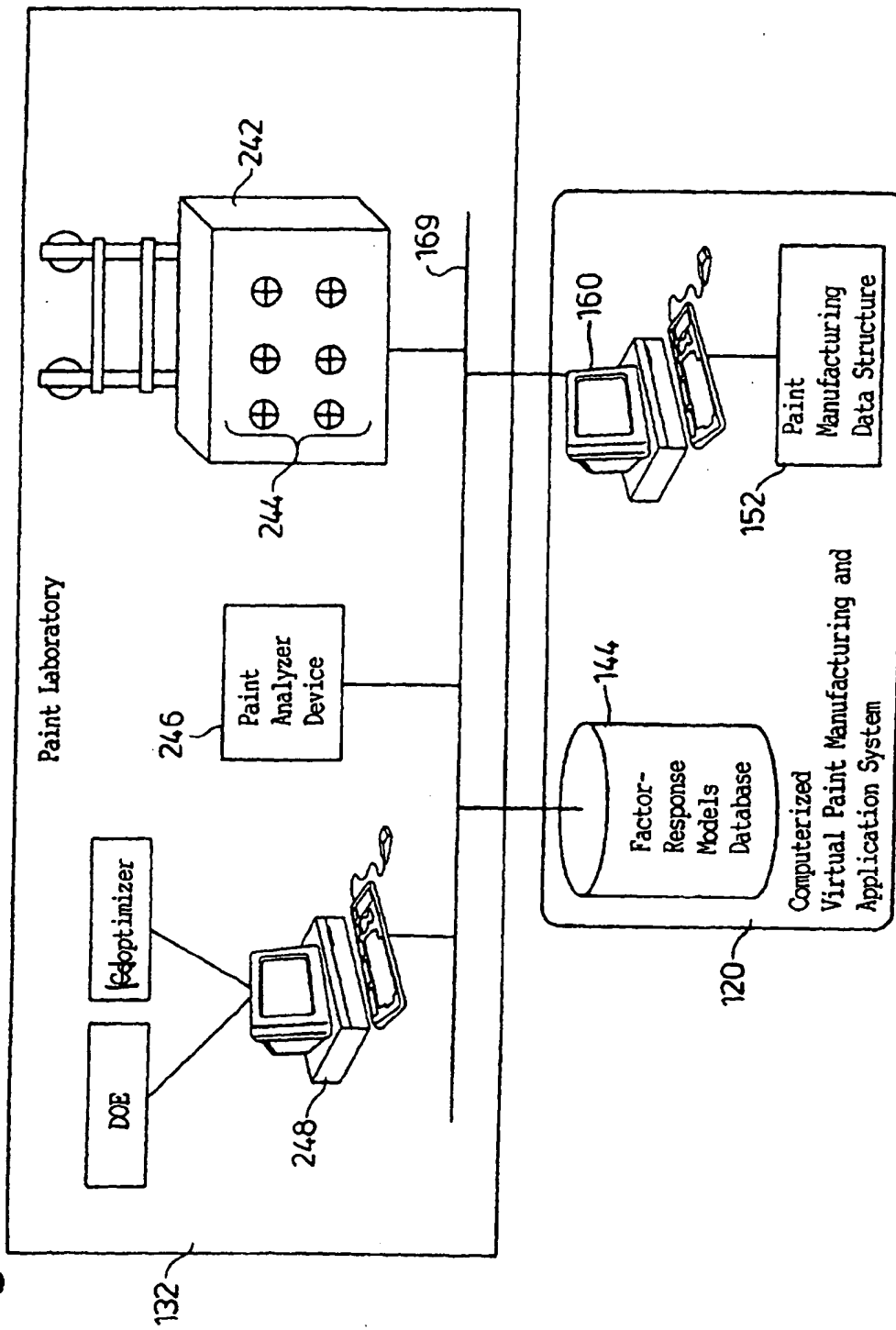
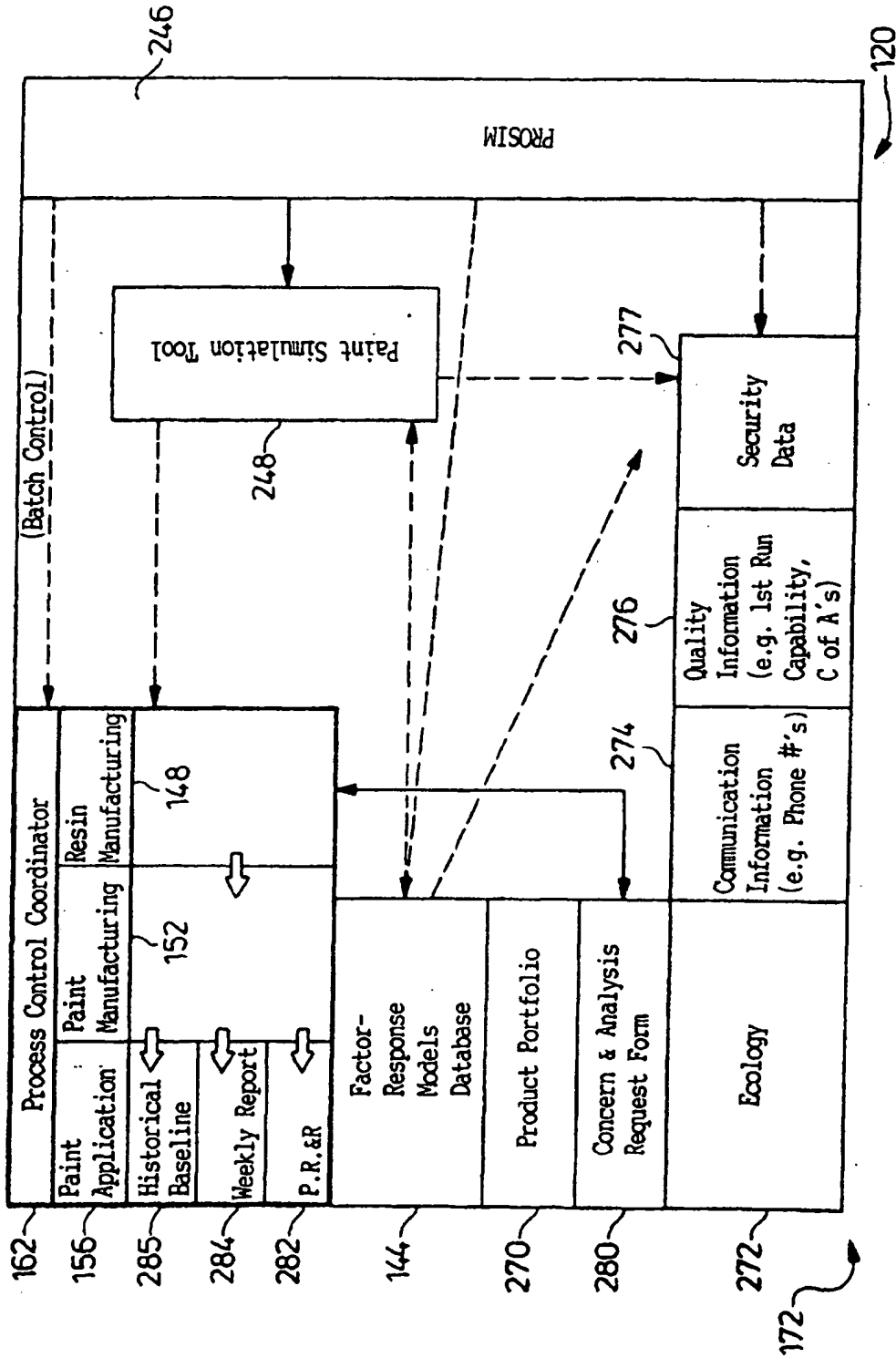
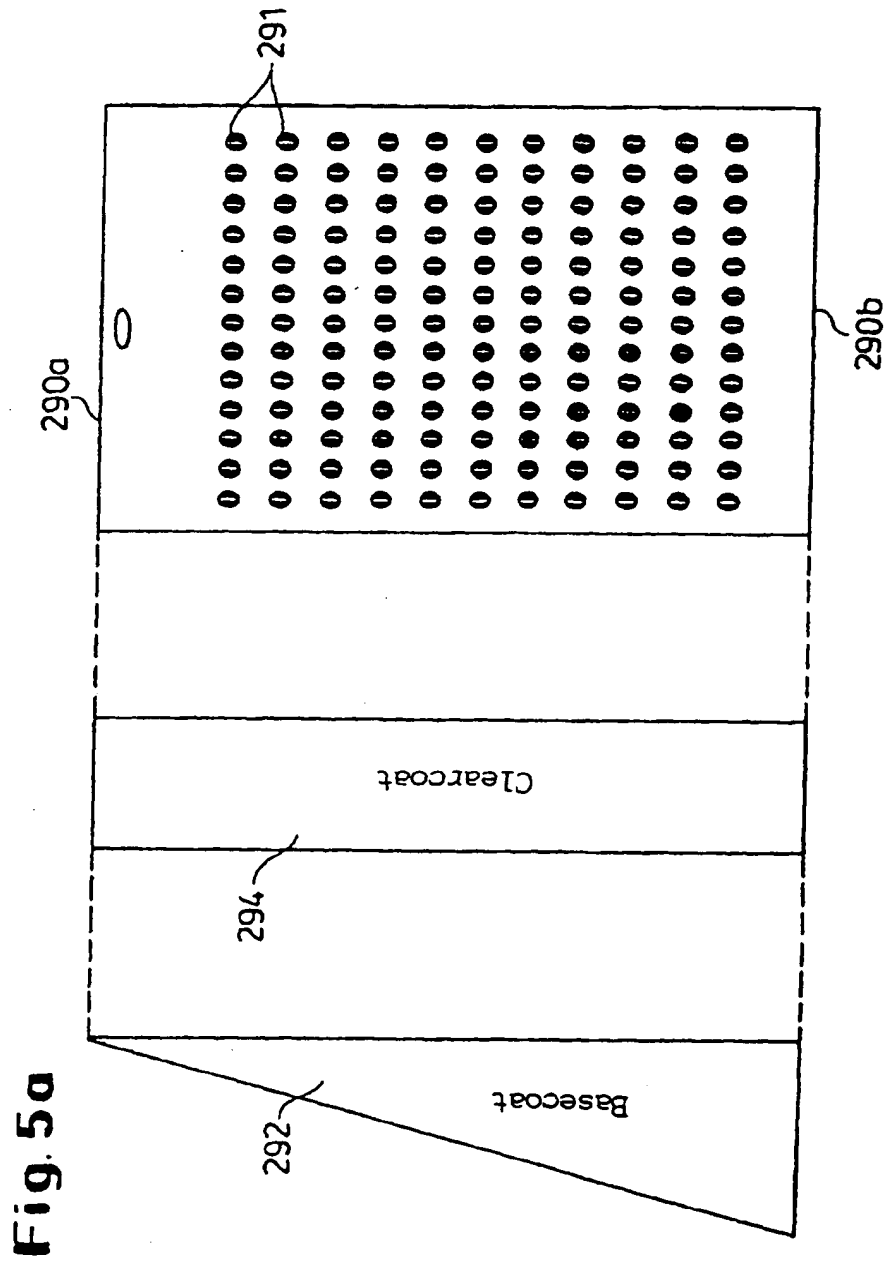


Fig. 4





**Fig. 5b**

Alusilber FE 81-917M #6458617  
L\*75-Helligkeitsverteilung

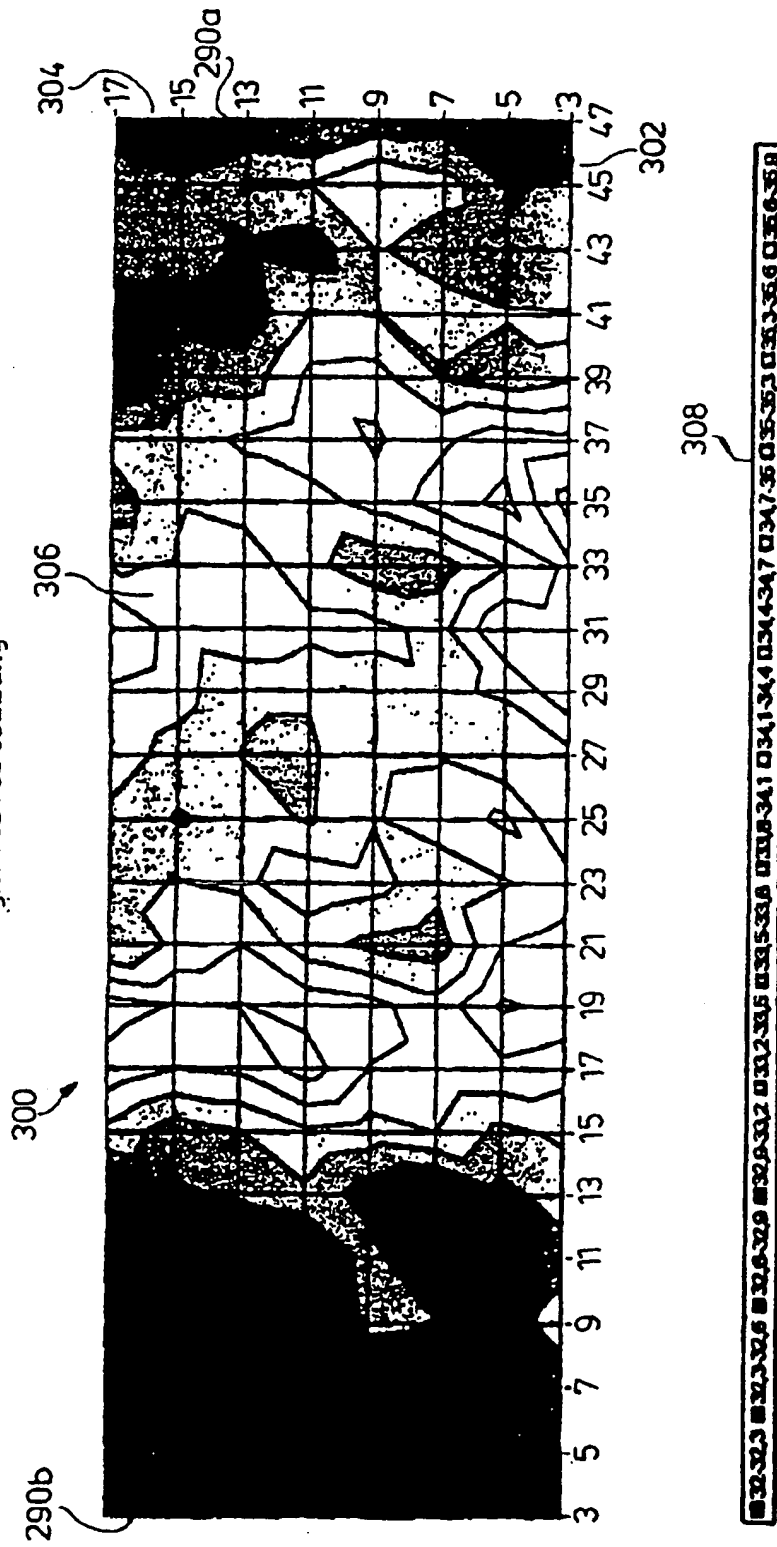


Fig. 6a

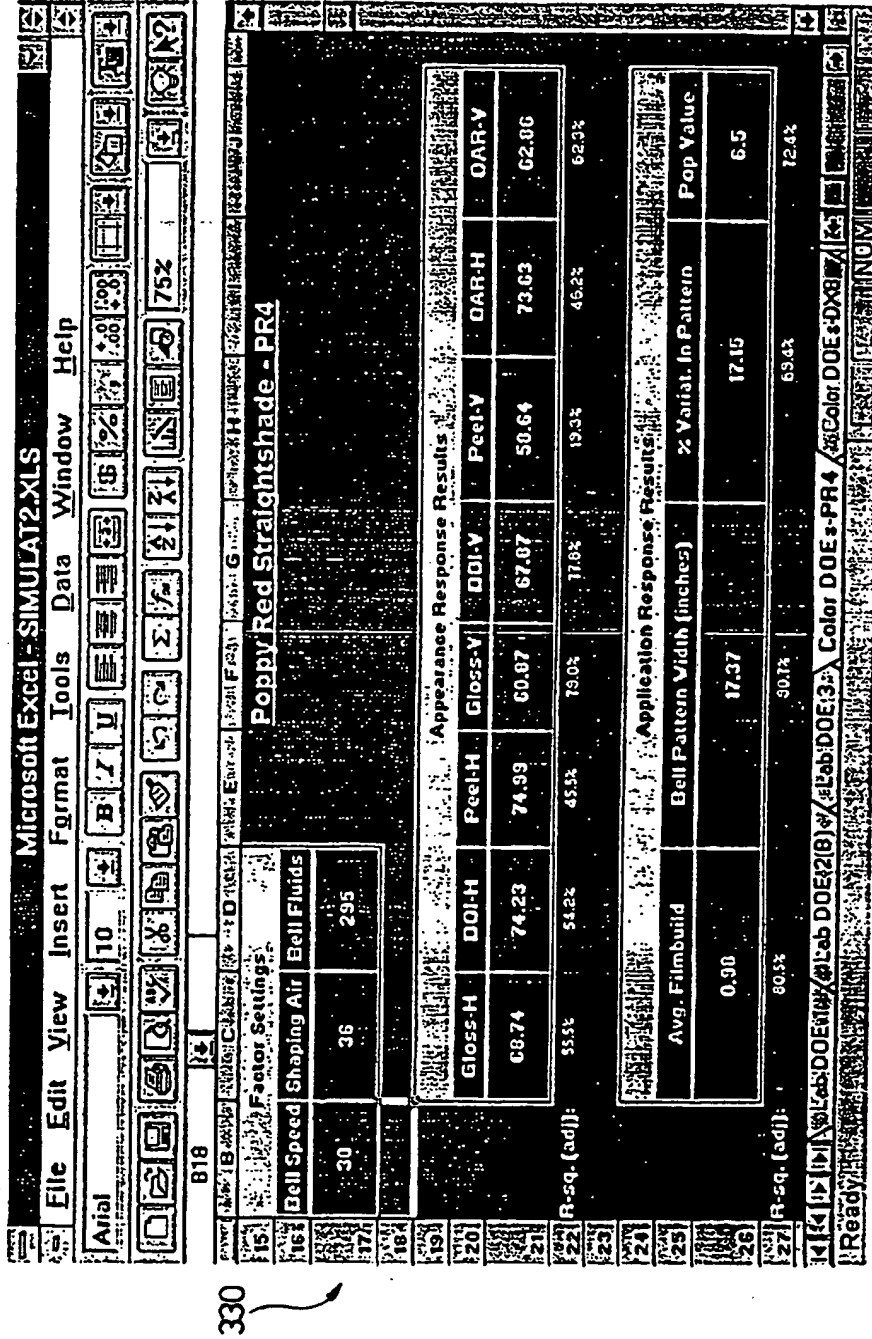
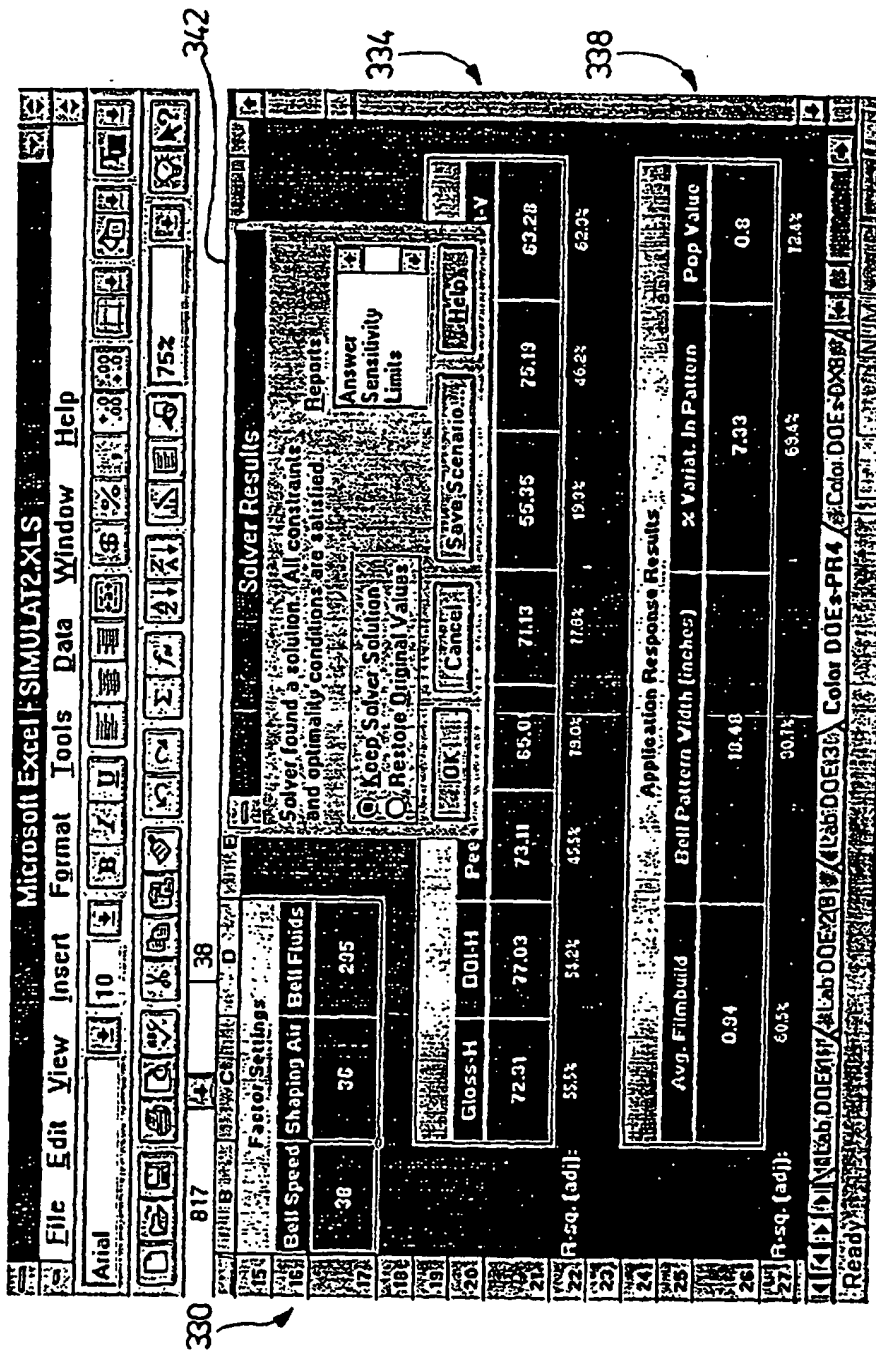


Fig. 6b



**Fig. 7a**

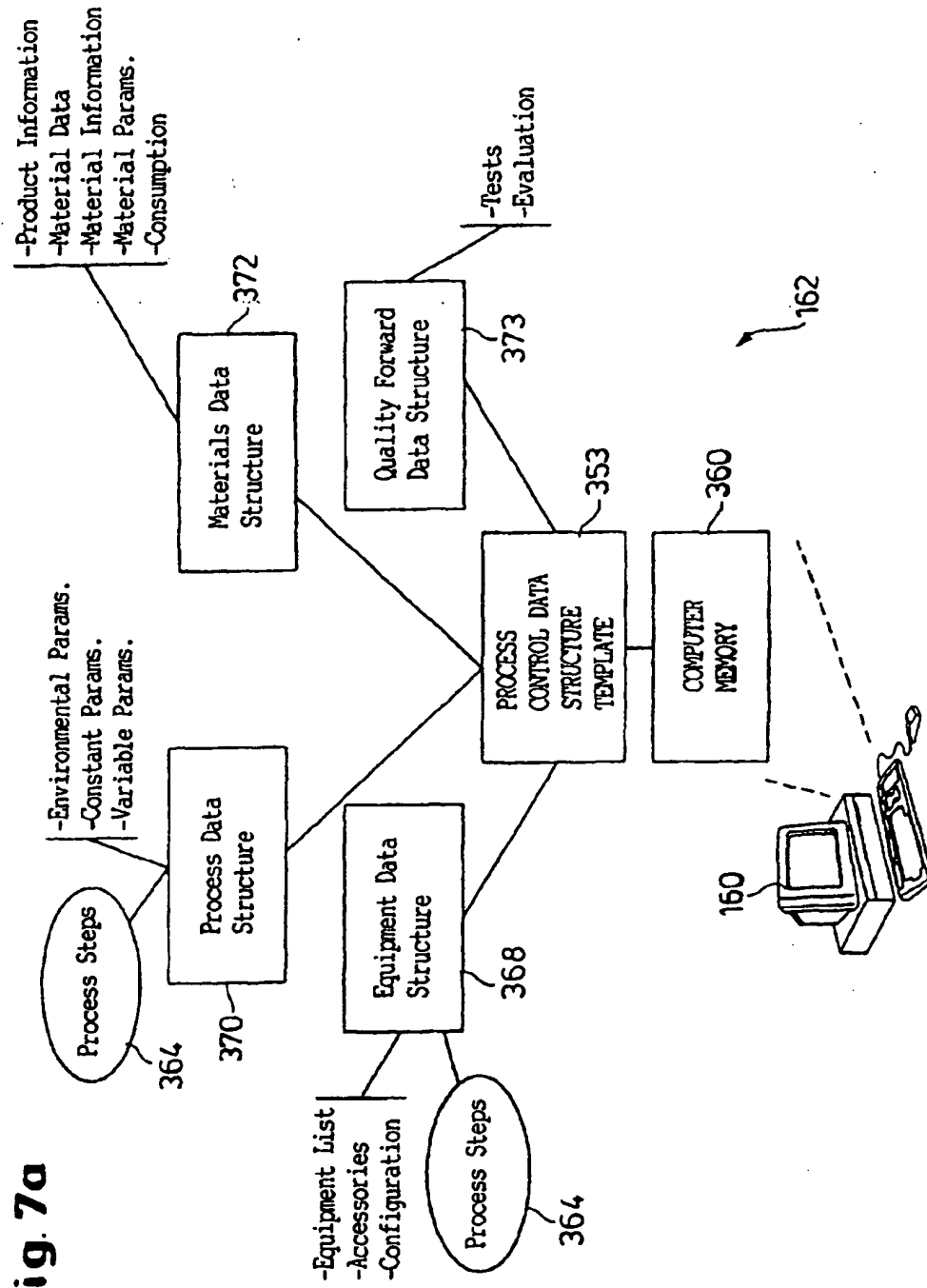


Fig. 7b

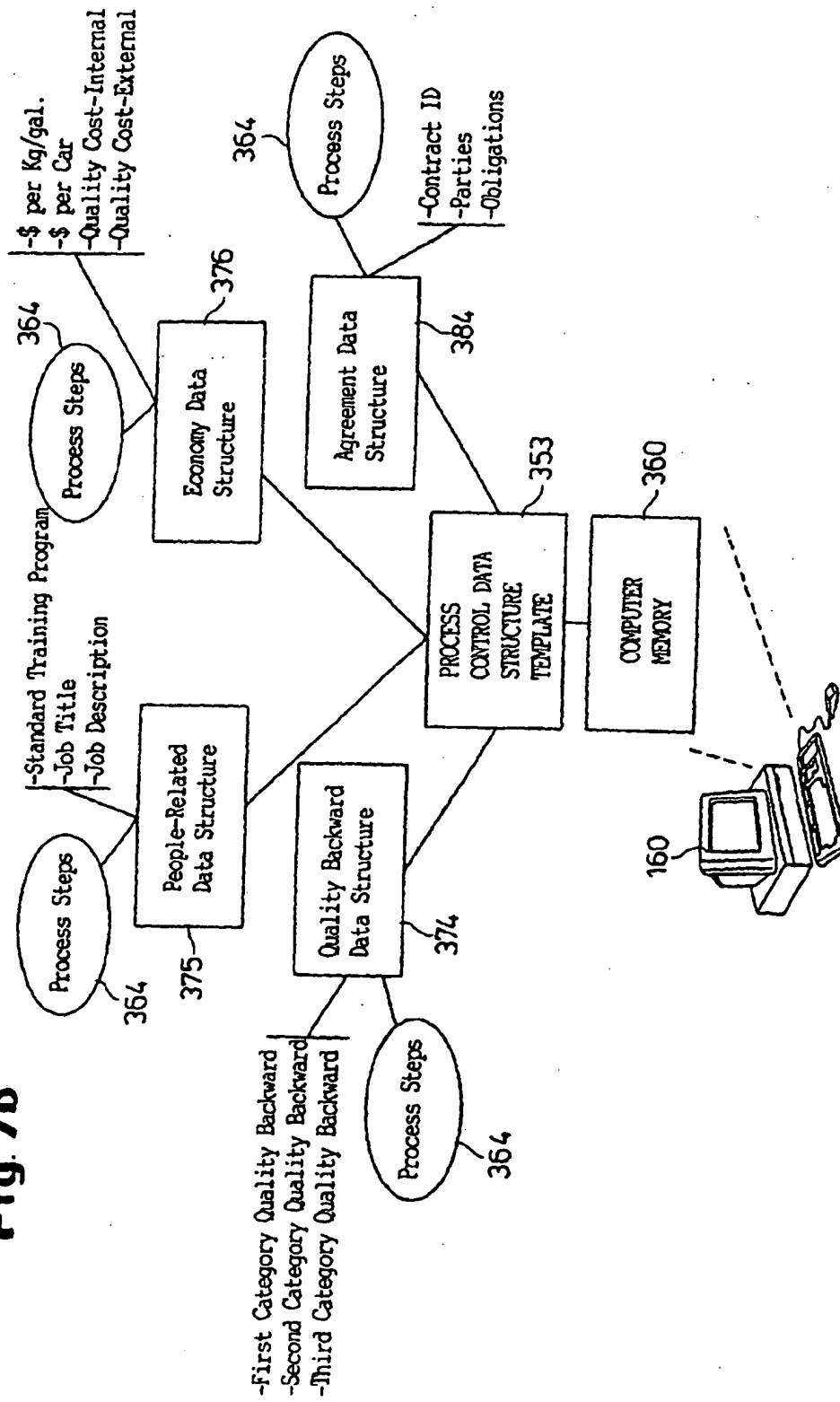


Fig. 8

Resin Manufacturing Data Structure																
Site information				Core Process Steps												
				Batch production												
First run rating																
Capacity Production figures Number of Employees Jobs	Water			Material receipt	Material storage	Reactor/Vessel prep.	Intermediate processing	Reactor/Vessel charging	Processing	Batch adjustment	Material transfer	Filtration	Filling	Equipment clearing	Production storage	Product delivery
	Energy															
	Air															
	Emissions															
Equipment	Equipment			Equipment	Accessories	Configuration	Environmental parameters	Constant parameters	Variable parameters	Product information	Material data	Material information	Material parameters	Consumption	Tests	Evaluation
Process																
Chemicals																
Quality Forward																

148

[illegible]

Fig. 9

Paint Manufacturing Data Structure																					
Site information					Core Process Steps																
Capacity Production figures Number of Employees Jobs					% First run rating					Batch production											
					Water					Material receipt	Material storage	Staging of materials	Equipment preparation	Raw material transfer	Intermediate processing	Batch blending	Batch adjustment	Filling process	Equipment cleaning process	Product storage	Product delivery
					Energy																
					Air																
					Emissions																
Equipment		Equipment			Equipment																
Accessories		Accessories			Accessories																
Configuration		Configuration			Configuration																
Environmental parameters		Environmental parameters			Environmental parameters																
Constant parameters		Constant parameters			Constant parameters																
Variable parameters		Variable parameters			Variable parameters																
Product information		Product information			Product information																
Material Data		Material Data			Material Data																
Material Information		Material Information			Material Information																
Material parameters		Material parameters			Material parameters																
Consumption		Consumption			Consumption																
Tests		Tests			Tests																
Evaluation		Evaluation			Evaluation																

152

[illegible]

[illegible]

# Fig.10

Paint Application Data Structure																														
Site Information				Core Process Steps																										
Capacity	Production figures	Type of vehicle(s)	Number of Employees	Jobs	First run rating			Paint shop operations																						
					Water	Energy	Air Emissions	1	2	3	4	5	6	7	8	9	10	11	12	13	14									
Equipment	Accessories	Configuration	Environmental parameters	Constant parameters	Variable parameters	Product information	Material data	Material information	Material parameters	Additions	Consumption	Tests	Evaluation																	
Process	Material	Quality	Forward	Evaluation	Storage-customer	Storage-customer mixroom	Mixroom	Pro-cleaning	Phosphate	Electrocoat	Cleaning-manual	Cleaning-automation	Manual application	Robots-Interior/Exterior	Rotational Atomizers-Bells	Air Atomizers-Reciprocator	Flash-off	Blow-off	Infrared	Ovens	Misc. Automated applications	Manual auxiliary operations	Automatic auxiliary operations	Zone w/o application operation	Sealant	Underbody Prime	Wax	Window glazing	Transportation Concerns	Coagulation

Quality Backward	Defect-Kind/type																					
	1 Quantification																					
Quality Backward	Evaluation																					
	Problem description																					
	Interim containment actions																					
	Potential cause(s) identification																					
	2 Root cause identification																					
People	Verification of corrective actions																					
	Permanent corrective actions																					
	Preventative actions																					
	Standard training program																					
	BASF services																					
Economy	Description of services																					
	Per Kg/gal.																					
	Per car																					
Agreement	Quality cost-internal																					
	Quality cost-external																					
	Who does what? BASF/ Customer																					
	Contract-Customer																					
	Contract-Tier 2 supplier																					

Fig. 11a

Data Structure ==>			
Module within Data Structure ==>	Materials	Quality	Process
Product Information	Defect	Environmental Parameters	Material Data
832-1435: Metallic Dk. Blue Blue 1s-way off color-27.00LAB			
Resin #305 and #419 used to formulate 832-1435			

RESIN MANUFACTURING DATA STRUCTURE			
Materials	Equipment	People	Quality
Product Information	Equipment	Job Title	in-process batch Control
Resin #305	Reactor Vessel 32A	T. Smith (chief resin reaction operator)	Quality Assurance Test #10 used at 10:00 am on 7/7/97 and satisfied since viscosity at 35 cps. For best results with Resin #305: Use Quality Assurance Test #10 wherein Viscosity should be within the range 30-40 cps.
Resin #419	Reactor Vessel 33A	T. Smith (chief resin reaction operator)	Quality Assurance Test #10 used at 10:07 am on 7/7/97 and satisfied since viscosity at 37 cps. For best results with Resin #419: Use Quality Assurance Test #11 wherein the Viscosity should be within the range 40-50 cps.

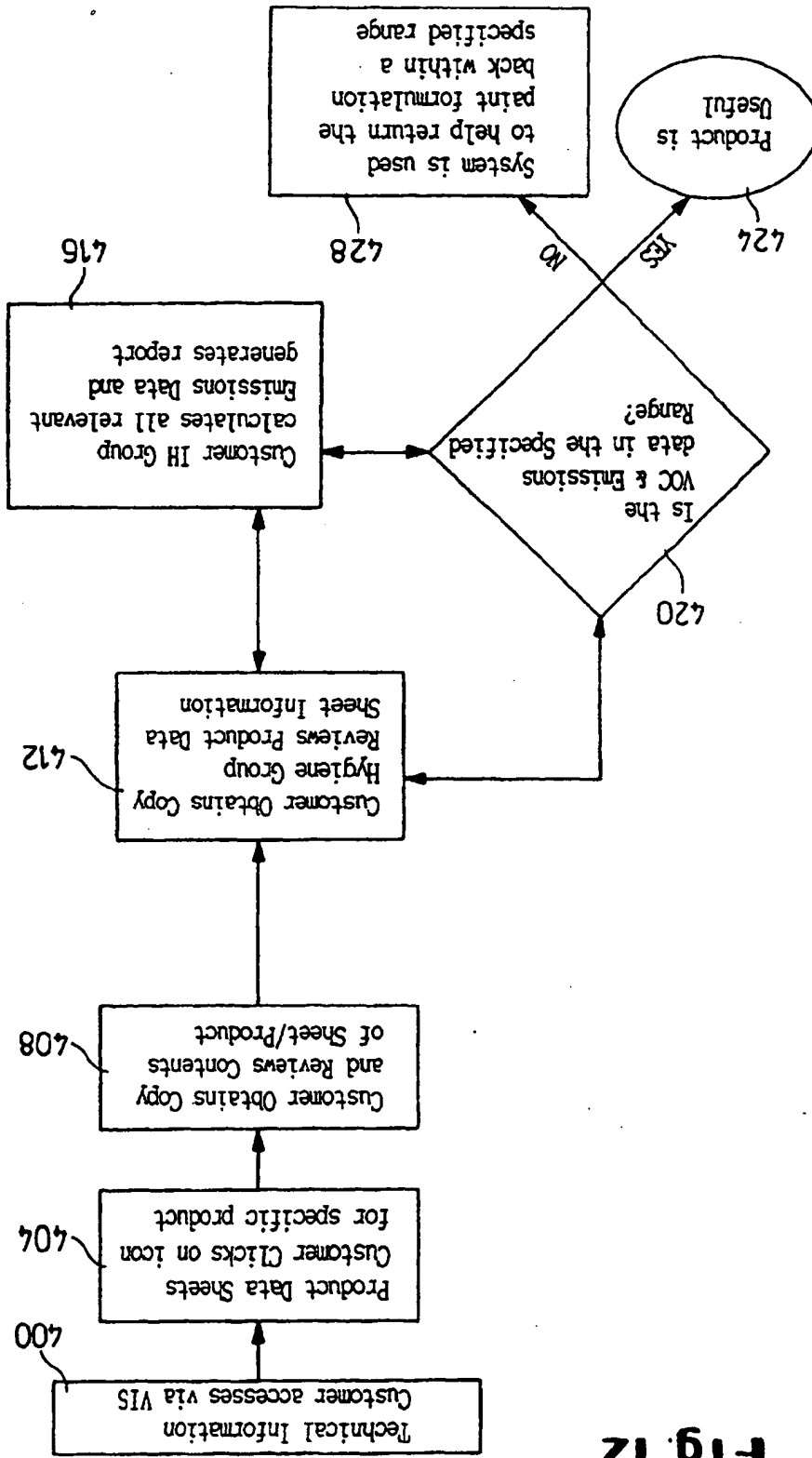
# Fig. 11b

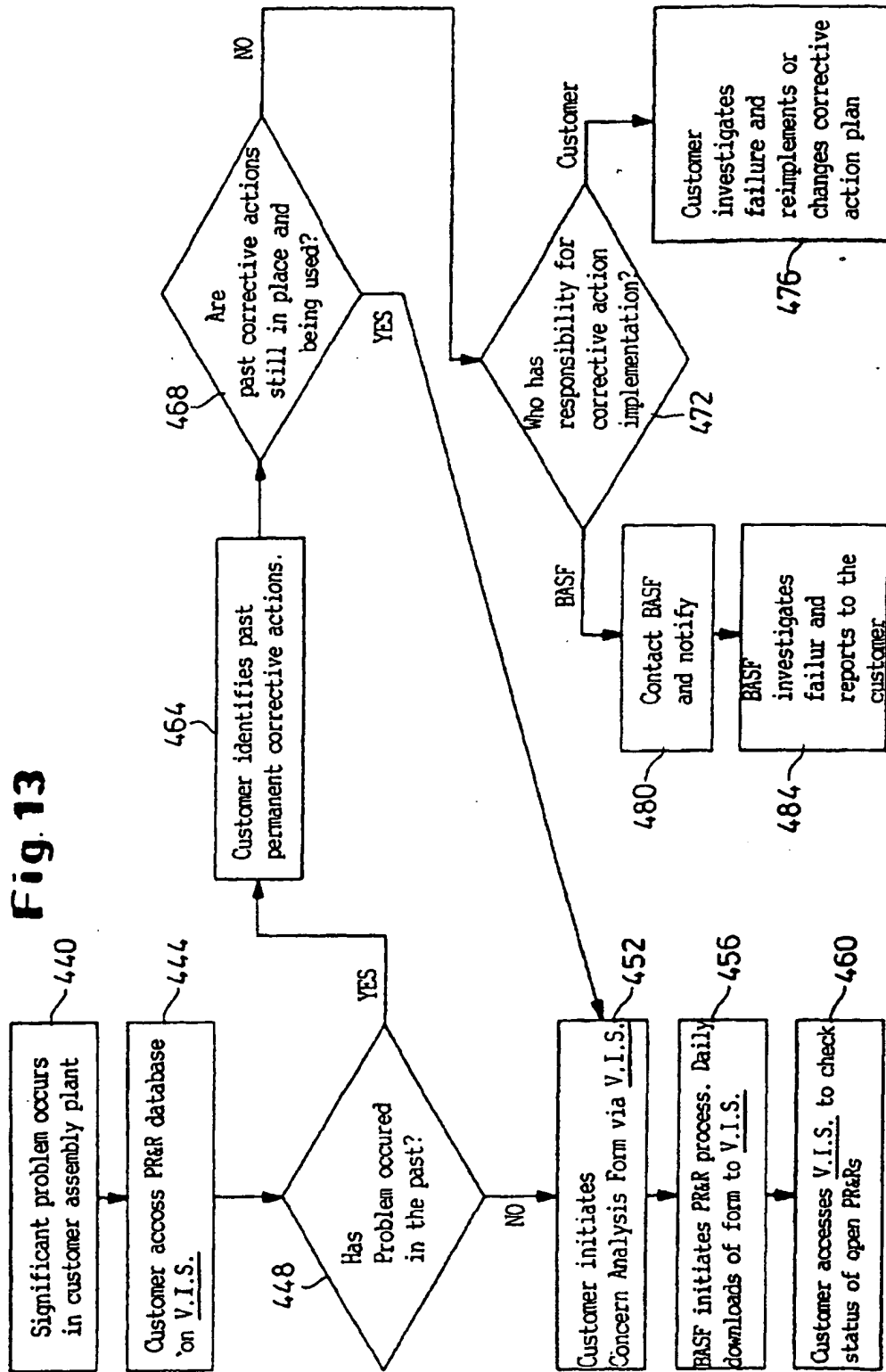
Level of authorization for security

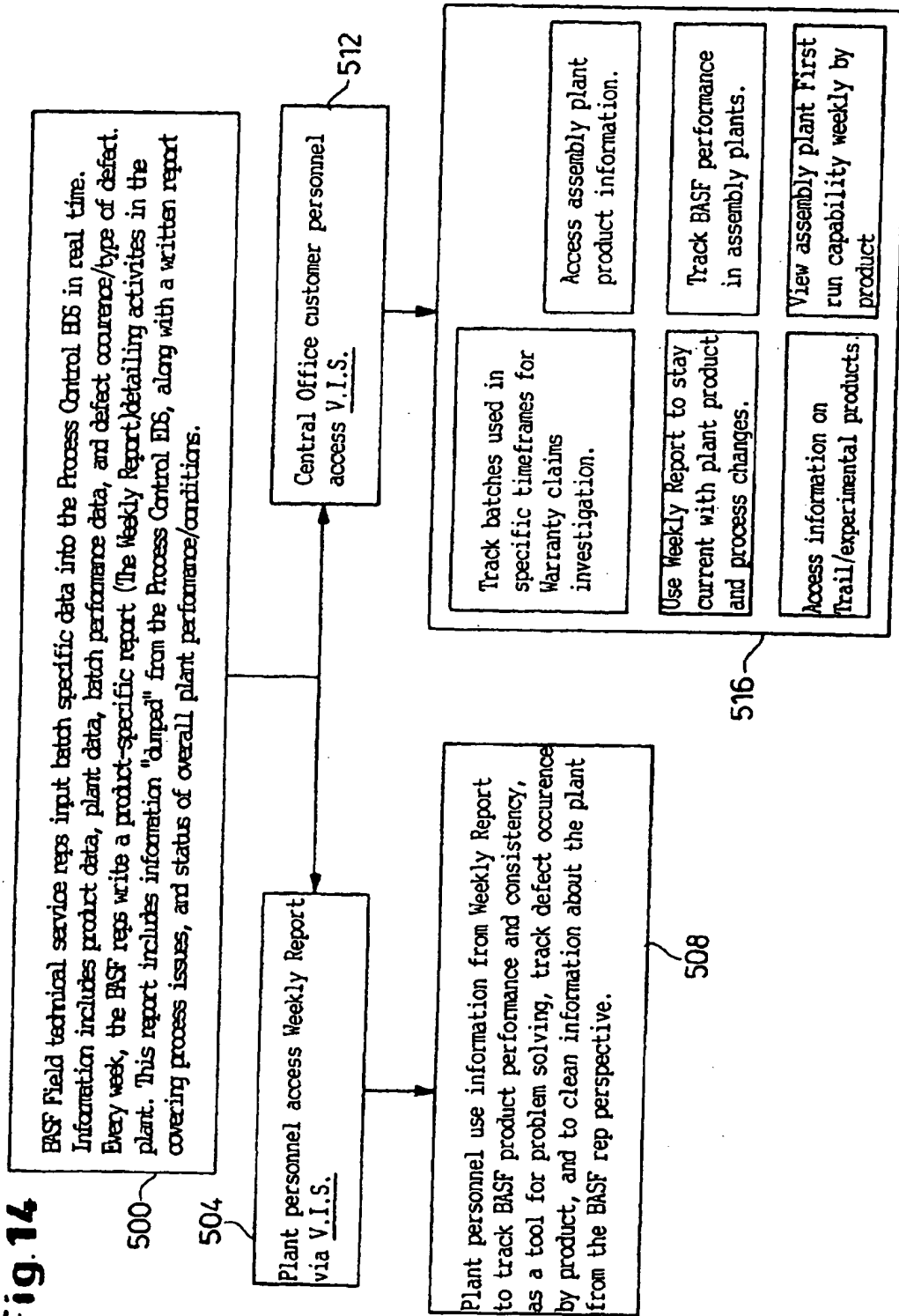
277

Paint Manufacturer	Process Control Data						View Netscape software		
	Oracle software	View only	Netscape software	View	Netscape software				
	1 plant 1 customer	1 plant 1 custom.	Multiple pl. 1 customer	All plants 1 customer	All plants All custom.	1 plant 1 custom.	All plants 1 customer	All plants All custom.	
FTSRs	X	X							X
Account mgrs.			X						X
CTS Project leaders			X						X
CTS Associates			X						X
Account Leaders				X					X
Directors					X				X
PCN.I.S. team					X				X
CUSTOMERS									
Plant paint area mgrs.									
Plant engineers						X			
Plant personnel						X			
Platform teams							X		
Central office personnel								X	

Fig. 12



**Fig. 13**

**Fig. 14**

**Fig. 15****Weekly Reports****Selected search conditions:**

Plant : U.S. Test  
 Period : Week 39 / 1997 until Week 43 / 1997  
 Products : all layers

Week 41 1997	Show the batch evaluations of this week	
	Metallic	Dk. blue is way off color- 27.00LAB Silver met. running OK. Red metallic is running better than normal. Spraying wetter, no mottle.
	Show the batch evaluations of this week	
Week 43 1997	Fuller	Smoke Primer is Cratering
		Red Primer is Running Well
		Grey and Titanium had Viscosity Problems.

**This Page is Inserted by IFW Indexing and Scanning  
Operations and is not part of the Official Record**

**BEST AVAILABLE IMAGES**

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images include but are not limited to the items checked:

☒ **BLACK BORDERS**

☐ **IMAGE CUT OFF AT TOP, BOTTOM OR SIDES**

☐ **FADED TEXT OR DRAWING**

☐ **BLURRED OR ILLEGIBLE TEXT OR DRAWING**

☐ **SKEWED/SLANTED IMAGES**

☒ **COLOR OR BLACK AND WHITE PHOTOGRAPHS**

☐ **GRAY SCALE DOCUMENTS**

☐ **LINES OR MARKS ON ORIGINAL DOCUMENT**

☐ **REFERENCE(S) OR EXHIBIT(S) SUBMITTED ARE POOR QUALITY**

☐ **OTHER:** \_\_\_\_\_

**IMAGES ARE BEST AVAILABLE COPY.**

**As rescanning these documents will not correct the image problems checked, please do not report these problems to the IFW Image Problem Mailbox.**